

Date: Tuesday, 31/03/2009 1:05:01 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 46754	
Estimate Number : 13168	
P.O. Number : ,	Part Number : D37411
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D3741 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 38825	Material :
Written By :	Due Date : 07/04/2009 Qty: 16 Um: Each
Checked & Approved By : <u>JW 09-03-31</u>	
Comment : Est Rev:A 08-01-30 new issue DD verified by:	
Est Rev:B 08-03-19 chg to revB DD verified by:	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6207 : M606116A 0.150 W.125 Angle Extrusion



Comment: Qty.: 0.0656 f(s)/Unit Total: 1.0500 f(s)

D6207 angle extrusion

Batch: M18147M18147

2.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: 1-drill holes as per dwg D3741

2-Deburr

SD 09/04/0316

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 09/04/0316

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 09/04/06SD 09/04/0616

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3741

2- Deburr if necessary

M.H 09/04/0616X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 - Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 46754

Part Number: D37411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/04/07 (16)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

CMO/BR

09/04/07

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FJ 09/04/07 (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STEVEN

09/4/8 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

16  
09/04/09  
MK 09-04-08

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

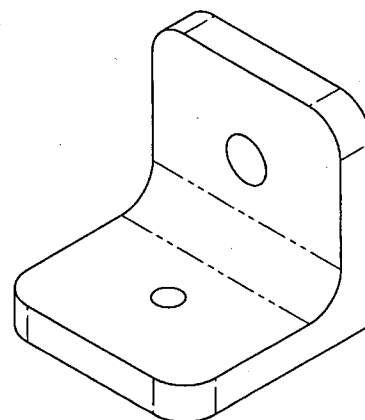
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





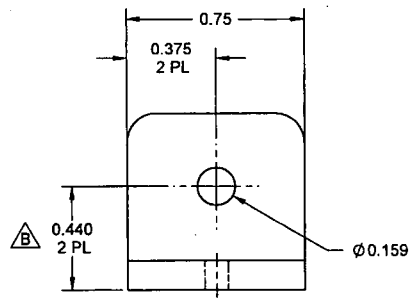
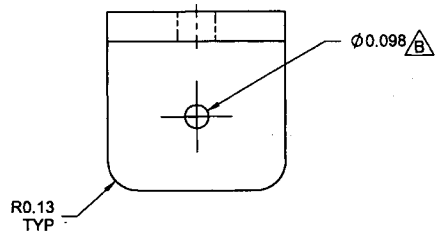
**D3741-1 ANGLE** B

NO. 110154  
 WORK ORDER  
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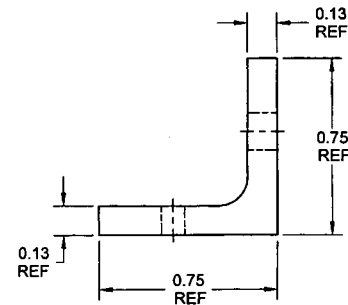
**NOTES:**

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125  
PER AMS-QQ-A-200/8  
(REF. DART SPEC. M6061T6A750XW125) B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED. SHEET 2 ZONE D5, Ø0.098 HOLE WAS Ø0.159, ZONE 6B 0.440 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>CE</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>IS</i>	D3741		SHEET 1 OF 2
APPROVED	<i>MP</i>	TITLE	SCALE	
DE APPR.	<i>JA</i>	ANGLE	NTS	
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**D3741-1 ANGLE**



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MFG. APPR.	DS	D3741	SHEET 2 OF 2
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